

Work Order ID 51617

August 27, 2009 8:27:08 AM

Page 1

Item ID: D3646-1 *BK*

Accept

Revision ID: B

Item Name: Arm

Setup Start

Stop

Start Date: 8/27/09 Start Qty: 10.00

Required Date: 9/11/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *R*

QC:

Date: *08-27*

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3646

Rev A

100



Brake NC

Brake NC

NC BRAKE

Memo

I-Punch to length as per Dwg D3646 & template DT8958

0.00

0.00

M-L 09/09/10

10X

110



Small Fab

Small Fab

Small Fab

Memo

I-Deburr

0.00

0.00

M-L 09/09/10

10X

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 8 02/02/10

10X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M109091

7:56pm

370°F

8:26pm

0.00

7/11 09/09/14

Y10

Ø

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BL 09-09-14

10.

150



Packaging

Packaging

Identify as per dwg & Stock Location 229

0.00

Memo

0.00

9/9/14

10x S10

W/O:		WORK ORDER CHANGES					
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Start Date: 8/27/09

Start Qty: 10.00

Required Date: 9/11/09

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

09/09/15

PL 09-9-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

August 27, 2009 8:27:08 AM

Page 1

Work Order ID: 51617

Parent Item: D3646-1RevB

Parent Item Name: Arm

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	272.6230	20.8421			



304 RD Tube .500 x .035W

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 10.00

Required Qty: 10.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

272.6230097

108250

2.23

111097

24.687936

111704

31.6682737

112187 ✓

214.0368

M-h 09/09/10 (10X)

N112187

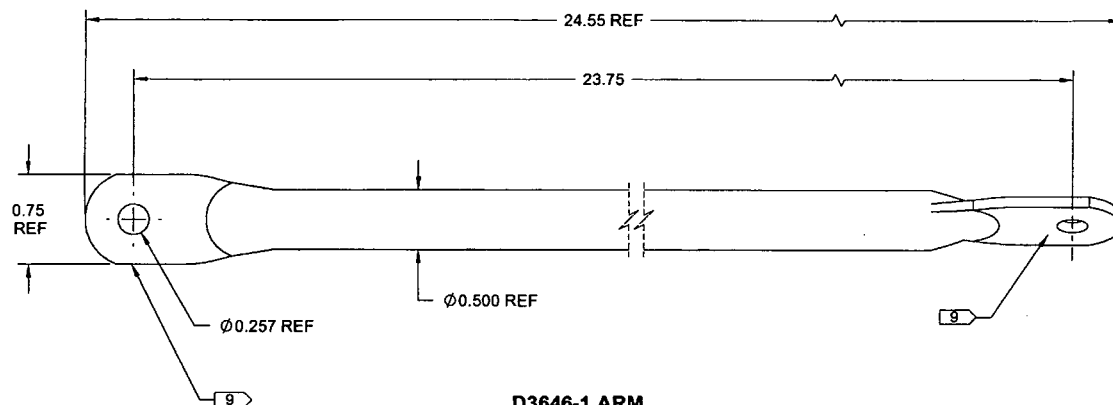
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

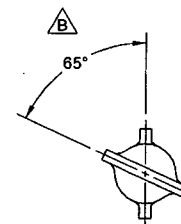
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NOTE: Date & initial all entries



D3646-1 ARM



51617

RELEASED
09/06/23

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\Phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) MAKE PER TEMPLATE DT8958
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3646** REV. B
SHEET 1 OF 2
TITLE **ARM** SCALE NTS

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